

Work Order ID 84731

84731

Page 1

May-22-12 1:07:04 PM

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 22/05/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2563	Rev C

100	Large Fab	0.00
100		
Large Fab	Memo	0.00
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563	
	2-Deburr ends	
	3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343	
	4- Grind	

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
110		
QC	Memo	0.00
Quality Control		

6 0 Ae
12.05.23
12.06.14

6 0 12.06.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84731

May-22-12 1:07:04 PM

84731

Page 2

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 22/05/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S17loc126		(x6)			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6		126.28	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6	d		12.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84731

84731

Page 3

May-22-12 1:07:04 PM

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 22/05/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>120854</u> Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind	0.00 0.00				<u>6</u>	<u>0</u>		<u>12-07-03</u> <u>12-07-03</u>
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							<u>8/17/07/03</u>
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>6</u>			<u>8/17/07/03</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84731

May-22-12 1:07:04 PM

84731

Page 4

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 22/05/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175 *175* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Touch up Alodine as per QSI005	0.00 0.00				6	NR	12-7-4	
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 9:45 OVEN TEMPERATURE: 320°F FINISH TIME: 10:15	0.00 0.00				6X	Ø	12/07/04	ML
190 *190* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch Memo	0.00 0.00				6	Ø	12/07/05	

M121841

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84731

Page 5

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 22/05/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 05/06/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

200

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location:_____

0.00

210

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

1120711

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:07:08 PM

Page 1

Work Order ID: 84731

84731

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116		Manufactured	No			100	Each	76.5000	1	6			
D2244-116													
Step Extrusion													

**

Ac 12.05.23

				<u>Location</u>				<u>Loc Qty</u>					
				WA				76.5					
								76.5					
				80803									
D2561		Manufactured	No			100	Each	44.0000	2				
D2561													
Lug													

**

12.06.13

				<u>Location</u>				<u>Loc Qty</u>					
				WA				39					
				80813				13					
				84326				26					
				WA015				5					
				66813				5					
D2564		Manufactured	No			100	Each	40.0000	2	12			
D2564													
Mounting Angle													

**

12.06.13

				<u>Location</u>				<u>Loc Qty</u>					
				WA				40					
				83429				24					
				83712				16					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:07:08 PM

Page 2

Work Order ID: 84731

84731

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 6.00

Required Qty: 6.00

D2673-34

Manufactured No

100

Each

91.0000

1

6

D2673-34

End Plate

**

12.06.14

Location

Loc Qty

Loc Code

WA

91

81468

2

84535

89

2
7

D2673-34

Manufactured No

150

Each

91.0000

1

6

D2673-34

End Plate

**

12.07.03

Location

Loc Qty

Loc Code

WA

91

81468

2

84535

89

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

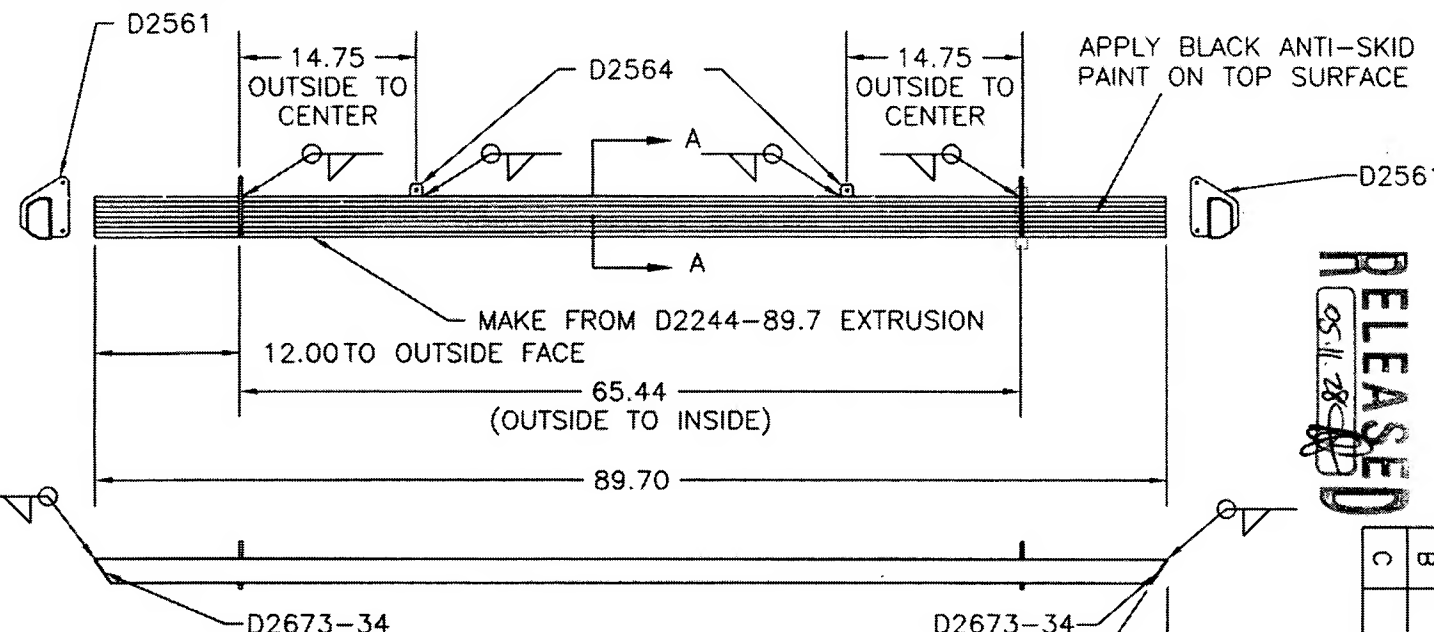
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	pt	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
pt	pt	D2563
DATE	TITLE	REV. C
05.11.14	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
A	NEW ISSUE	SCALE
B	END CAPS CHANGED (WAS D2248)	1:15
C	UPDATE NOTES	



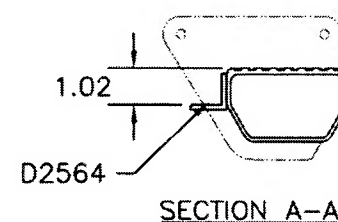
D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84731 MLJ
12/05/22



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED